



Dart Aerospace Ltd.
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Tel (613) 632-5200

D3254-2
Job Sheet 169524



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Part No: D3254-2

Job Qty: 6 ea

Part Name: Side RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/29/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

NAV
DAS
DEV A

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/28/17	0.00	0.00	Start Up Waterjet		Je 18/01/20
100	Waterjet	6 pcs		12/28/17	0.00	1.53	Waterjet1		Sc 18/01/20
110	QC	6 pcs		12/28/17	0.00	0.00	QC2 Waterjet-1		Sc 18/01/20
120	QC	6 pcs		12/28/17	0.00	0.00	QC8-2		38
130	Small Fab	6 pcs		12/28/17	0.08	0.70	Small Fab-3		9-58 DAS 38
140	QC	6 pcs		12/28/17	0.00	0.00	QC5		38
150	HandFinish	6 pcs		12/28/17	0.00	0.61	HandFinish1		18-02-08
160	Powdercoat	6 pcs		12/29/17	0.00	0.37	Powdercoat4		18-02-31
170	QC	6 pcs		12/29/17	0.00	0.00	QC3		38 58-6
180	Packaging	6 pcs		12/29/17	0.00	0.00	Packaging3-1	8.248	38 9
190	QC21-SA	6 Ea		12/29/17	0.00	0.00	QC21		FEB 22 2018 21 FEB 22 2018

Part Op 100 - 1-Cut D3254-1as per Dwg D3254

Descriptions: 130 - Bend as per dwg D3254

160 - START TIME: 1:40. OUT: 320° FINISH: 2:10. M138700

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.063	38	261	0	0

Sc 1837

④

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

A Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QS1042) Approval
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Description Work Order		Completed By
Start up Operation 01/20/18 Job No: 169524		Lead hand / Supervisor Approval Verification
Change No: Operation: Revision: Original Serial #: S034021 PART NO: D3254-2		QC / QA Coordinator Approval

Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		OTHER :	
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DART AEROSPACE LTD		Work Order:	169524
Description: Side (Dual Battery Rack)		Part Number:	D3254-2
Inspection Dwg: D3254 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.20	+/-0.030	5.207	1			
4.15	+/-0.030	4.158	1			
R0.19	+/-0.030	R0.19	1			
1.103	+/-0.010	1.105	1			
0.300	+/-0.010	0.302	1			
Ø0.098	+0.005/-0.000	Ø0.098	1			
1.300 Pitch	+/-0.005	1.301	1			
21.056	+/-0.010	21.057	1			
19.000	+/-0.010	19.002	1			
1.003	+/-0.010	1.004	1			
Ø1.125	+0.005/-0.000	Ø1.125	1			
5.403	+/-0.010	5.404	1			
Ø1.500	+0.005/-0.000	Ø1.501	1			
2.750 Pitch	+/-0.005	2.750	1			
5.500	+/-0.010	5.500	1			
1.653	+/-0.010	1.654	1			
3.75	+/-0.030	3.758	1			
10.810	+/-0.010	10.811	1			
8.00	+/-0.030	8.00	1			
R0.50	+/-0.030	R0.50	1			
2.750 Pitch	+/-0.005	2.750	1			
4.125	+/-0.010	4.126	1			
22.946	+/-0.010	22.947	1			
R0.30	+/-0.030	R0.30	1			
9.90	+/-0.030	9.906	1			
11.77	+/-0.030	11.78	1			
1.82	+/-0.030	1.825	1			
2.17	+/-0.030	2.176	1			
20.10	+/-0.030	20.10	1			
0.953	+/-0.010	0.954	1			
R0.125	+/-0.010	R0.125	1			
Grain along 20.10	N/A	OK	1			

Measured by:	SC	Audited by:	38	Prototype Approval:	N/A
Date:	18/01/20	Date:	FEB 07 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	